

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 129965

129965

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February-23-15 10:35:00 AM

Item ID: D2175-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle LH
 Start Date: 2/23/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				(4)			DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									MAR 09 2015
130		0.00							
130	Small Fab				DAS 30 9-89	N/A			
Small Fab	Memo	0.13							
Small Fab	Deburr Stack								
140		0.00							
140	NC BRAKE				DAS 30 9-89	4			15/03/14
Brake NC	Memo	0.01							
Brake NC	Form as per Dwg D2175								

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Angle LH

Start Date: 2/23/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 2/23/15 **Req'd Qty:** 4.00 ***A***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

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Page 4

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: SP	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

4X SP15-03-13

MW 15-03-16

MF 15-3-16

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Picklist Print

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Page 1

Work Order ID: 129965

129965

Parent Item: D2175-1

D2175-1

Parent Item Name: Angle LH

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP E04.06.09ReformatKJ/RF
IPP Rev:F 06-04-28 Manufactured on Water Jet JLM
IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	265.0169	0.4722	1.988210			

M2024T3S 063

2024-T3 .063 sheet

**

02/15/03/08

Location

Loc Qty

Loc Code

MAT022

265.0169

m127866

16

m130000

9.3489

m130525

239.668

2.1

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DART AEROSPACE LTD		Work Order: 129965
Description: Angle		Part Number: D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	/			
R0.35	+/-0.030	.35	/			
2.915	+/-0.010	2.920	/			
50°	+/-0.5°	50°	/			
0.300	+/-0.010	.302	/			
1.050 Pitch	+/-0.010	1.050	/			
10.500	+/-0.010	10.505	/			
11.550	+/-0.010	11.555	/			
0.550	+/-0.010	.550	/			
0.900	+/-0.010	.900	/			
0.063 thick	+/-0.010	.063	/			
Grain Direction	N/A	/	/			
Ø0.128	+0.005/-0.001	Ø.127	/			
Ø0.172	+0.005/-0.001	Ø.171	/			

DAS

38
9-89

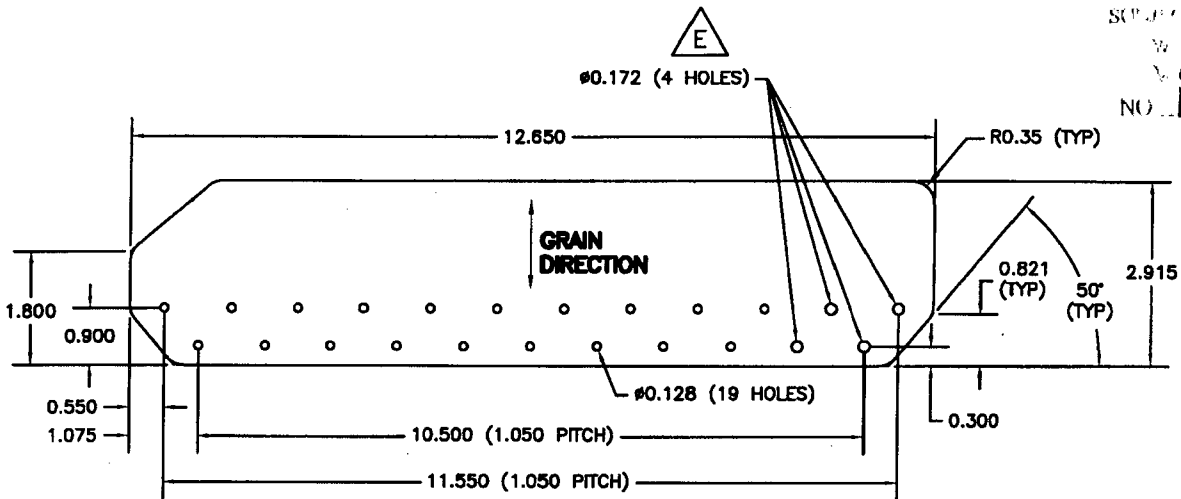
Measured by: <i>Dr</i>	Audited by: <i>38</i>	Prototype Approval: N/A
Date: 15/03/07	Date: MAR 09 2015	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	<i>[Signature]</i>

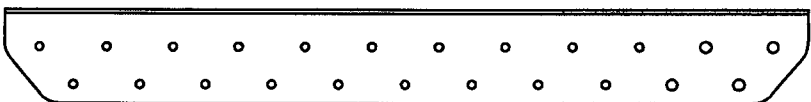
DART

06.10.13

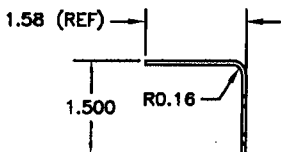
NO 129965
ML5
15-02-2



D2175-1E FLAT PATTERN



D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)



DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	[Signature]	DRAWING NO.	D2175
DATE	06.09.25		TITLE	ANGLE	
A		95.10.25	NEW ISSUE		
B		96.01.18	CHANGED DIMENSION		
C		00.09.11	UPDATE FINISH SPEC		
D		04.06.03	RE-DESIGN		
E		06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES		

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSIONS ARE IN INCHES